

EXHIBIT N

HEM CORP.

FRANKFORT, ILL. 60433

815-469-2335

P. O. BOX B

ASSEMBLY ORDER FOR PRESS BRAKE

PROGRESSIVE MACHINERY CO.

RD NO 1362

PTO: AYCON, WYOMING DIVISION 550 South Main St., Cheyenne, Wyo. 82001

PRESS BRAKE TO INCLUDE

Spec. Price	Spec. Description	Spec. Price	Spec. Description	Spec. Price	Spec. Description
STROKE	13	RAM INDICATOR	YES	COUNTER BALANCE	NO
WT. HEIGHT	12	RAM POWER	YES	RAM MACHINE FOR ANGLES	NO
TOR. HP	3	HORN EXT. RIGHT	NO	BED MACHINE FOR ANGLES	NO
TOR. RPM	3600	HORN EXT. LEFT	NO	WELDED ANGLES	NO
TOR. FRAME		LUBRICATION		PERMANENT	
ULLEY		ONE SHOT	YES	FLANGED BED	NO
ARTER-STD REV	YES	AUTOMATIC	NO	PERMANENT	
STAGE	1	TRU-KONTROL	YES	FLANGED RAM	NO
		PRESS BRAKE	NO	CAST BRACKET	NO
		TRU-KONTROL	NO	BOLSTER PLATE	NO
		PUNCH PRESS	NO	DIE BLOCK	NO
		PALM BUTTONS	NO	PAINT	NO
		FOOT SWITCH	YES	STUD	NO
		BACK GAUGE, FRONT	YES		
		OPER. MANUAL	NO		
		POWER	NO		

OPTIONAL EQUIPMENT

THIS VENUE IS SUBJECT TO CANCELLATION CHARGES.

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1	2	3	4	5
1	2	3	4	5
1	2	3	4	5
1	2	3	4	5

order is accepted subject to the right of the purchaser to cancel the same at any time prior to shipment upon written notice to this company at such cancellation and payment of a cancellation charge of twenty per cent of the total amount of the order. If such notice is received within fifteen days from the date of the order such cancellation charge will be waived.

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Horn Press

PF=Performance

INSPECTION SHEET PRESS BRA

Date	Model No. 90-6	Serial No. 2176				
Item	Check	Spec./Comment	OK By	Objection	Correction	OK By
Stroke	Dim. inches	3"	BT			
Shut Height	Ram to bed strk dn-adj. up	12"	BT			
Strokes/minute	Actual count	25 strokes	BT			
Flywheel	Exact dia. and thickness	24" x 3 1/2"	BT ✓	OK by WALLY & B. Ransoy		
Flywheel Rotation	Clockwise/counterclockwise	C.C.W.	BT			
V-Belts	Section size and length	B-85	BT			
V-Pulley	O.D. and bore	4460-80	BT			
Ram Adj. Up	Actual ram indicator reading	0.0180	BT			
Ram Adj. Down	Actual ram indicator reading	6.500	BT ✓			
Ram and Bed Alignment	Clamp bar on each end bring ram down & measure	1.5, 5 1/16 R. 5 1/16, 5 1/16	BT			
Lubricator	Make and size	Bylan One shot	BT			
Lube Type	Kind of oil or grease used	Shellard H.	BT			
Oil Meters (Ram Guides)	Actual size	#1	BT			
Oil Meters (Conn. Rods)	Actual size	#3	BT			
Meters (Main Brngs)	Actual size	#2	BT			
Oil Lines	Purged and fittings tight	OK	BT			
C'bal. Cylinders	Bore and stroke	N/A	BT			
C'bal. Cyl. Bar	Size and length	N/A	BT			
C'bal. Cyl. P.S.I.	Press. req'd to take up ram	N/A	BT			
C'bal. Pressure Sw.	P.S.I. set @	71 P	BT			
Main Pressure Sw.	P.S.I. set @	72 PSI	BT			
Clutch Hub	Bore & thickness	2 1/8" + 3"	BT			
Clutch Hub Lock	Type and tightness	nut & lock ring	BT			
Clutch Plates	Quantity and size	3 plate	BT			
Clutch Shims	Quantity and thickness	2 per pin	BT			
Clutch Operation	Friction and heat	OK	BT ✓			
Brake Hub	Shape, bore and thickness	2" x 2 1/8"	BT			
Brake Disc	Bolts, runout and concentricity	3 bolts	BT			
Brake Caliper(s)	Quantity bolts and run out	one	BT			
1st Mtg. Bolts	Dia, length and head clearance	1 1/2"; 1 1/2 clearance	BT			
Die Block	Position in groove and size	standard	BT			
Horn, Extension(s)	Length and R and/or L	No	BT			

Item	Check	Spec./Comment	OK	By	Objection	Correction	OK	By
Operat. Back Ga.	Type required				Back ordered			
Machine For Angles	Bed and/or ram	1/2						
Motor H.P. and RPM	From nameplate	5HP:3495						
Motor Volt and Frequency	From nameplate	220-440 volt						
Motor Starter	Make size and type	100/50 amp						
Heater Relays	Size Number	120T37						
Circuit Breaker	Make, amps and volt rating	15A 600V						
Press Controls	Quantity and type of oper. stations	1 copy						
Press Control Specs	Location and type of connection	Floor						
Motor Wiring	Wire size	#14						
Motor Start-Up	Time req'd for full flywheel rpm	7 seconds						
Elect. Dwg. Used	Dwg. number and date	D-7607 5/14/02						
Cams	Setting all modes and rotation	Set up by technician						
Lube Cycle	Actual time and oil amount	0.50						
In Bearings Clearance	Jack up ram with knuckle tight (loosen it after check)	.015						
Knuckle Clearance	Use feeler gauge & lock upper nut	.003						

Special Features and Notes

Location	Left	Right	
	Bottom .000	.000	
	Up .000	+ .005	
	Down .000	- .005	
RAM			